

Work Order ID 60031

June 23, 2010 8:34:34 AM



Page 1

Item ID: D2195-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 6/23/10

Start Qty: 2.00



Cust Item ID:

Required Date: 6/25/10

Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: C2

Date: 10/6/23

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2195

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2195 ☒ Dwg Rev: D ☐ Prog Rev: D ☐ 2-

Deburr if necessary

6061 .500 x 5'

B10-6-23

②

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-6-23

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S10/06/23

②

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 6/23/10

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00				(20)			
Small Fab	Memo	0.00							
Small Fab	1-open hole to finish size as per dwg □ 2- deburr								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00				12			
Quality Control									
150 	Chemical Conversion Coat per QS1005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

EMK 10/06/23

S10/06/23

MB 10 24 (2)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

Item ID: D2195-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 6/23/10

Start Qty: 2.00



Cust Item ID:

Required Date: 6/25/10

Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 BL 10-6-24,

170

Identify as per dwg & Stock Location: 8

0.00



Packaging

Memo

0.00

Packaging

10-6-25 sf (20)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/289
CZ 10/6/25

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 60031



Parent Item: D2195-3



Parent Item Name: Spacer

Start Date: 6/23/10

Required Date: 6/25/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-24 new issue ec verified by:dd
IPP Rev:B 09-01-28 rev.d as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X05.00 0		Purchased	No			100	f	53.9436	0.351	0.738947			



6061-T6 Bar .500 x 5.00



810-6-23

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT03	53.9436	
112041	20	
112154	33.9436	

112154

(2)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D2195	BRACKET ASSEMBLY
7	1	D2195-1	BRACKET
8	1	D2195-2	BRACKET
9	1	D2195-3	SPACER
15	6	MS20470AD4-14	RIVET

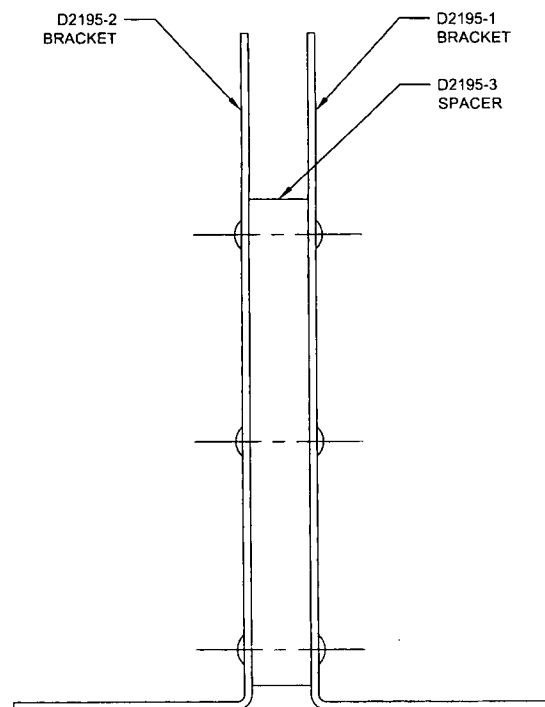
CL 10/6/23
W10:60031

NOTES:

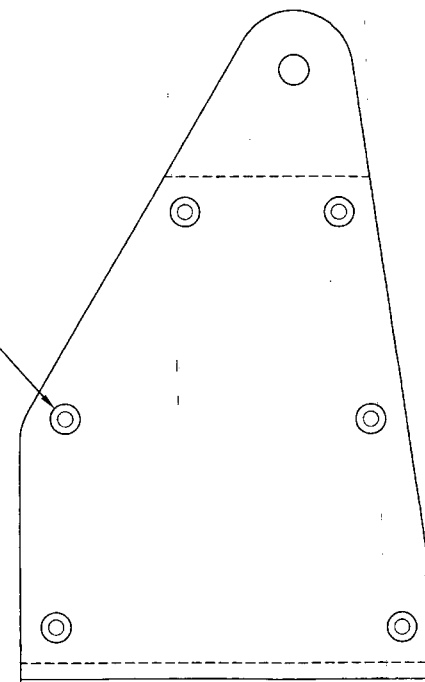
- 1) MATERIAL:
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2195" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.26 lbs

RELEASED
29/01/13/11/0

D	RE-DESIGN. REF NCR 08-110.	AJS	08.11.25
C	REDRAW: D2195-3 NOW 0.5" THICK	CP	03.05.28
B	RE-DESIGN	JB	93.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2195	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	08.11.25	<small>COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



MS20470AD4-14
RIVET
6 PL

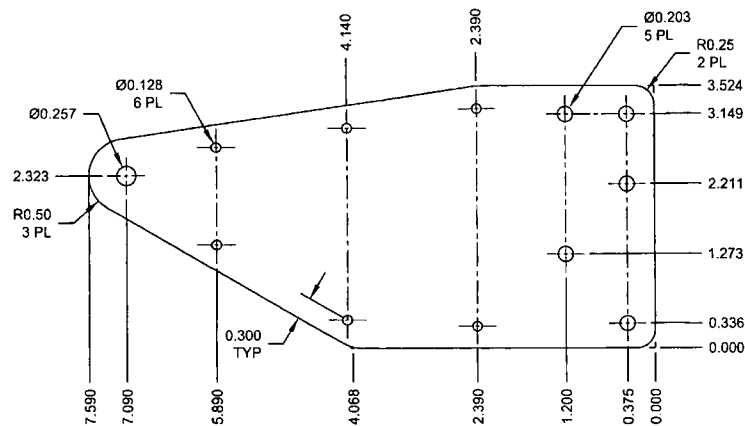


60031

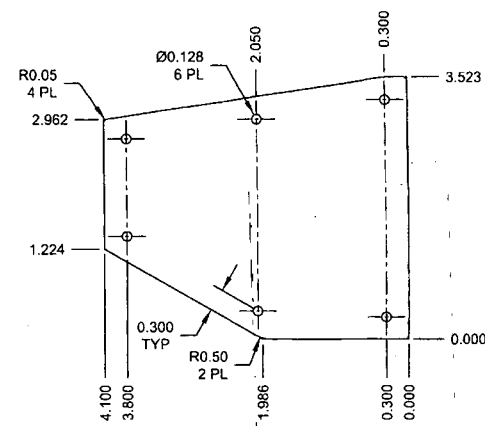
D2195 BRACKET ASSEMBLY

RELEASED
07/01/15

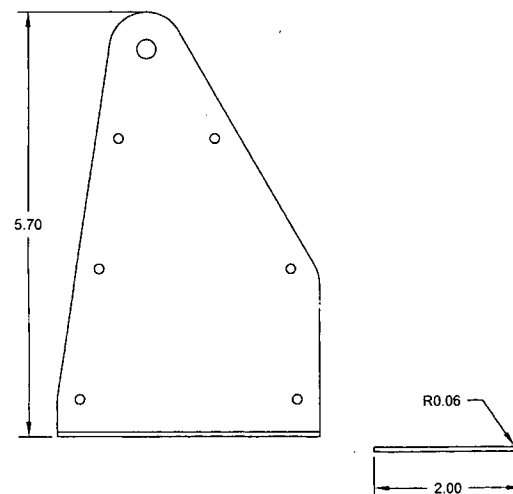
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	✓	DRAWING NO.	REV. D
MFG. APPR.	EO	D2195	SHEET 2 OF 3
APPROVED	✓	TITLE	SCALE
DE APPR.	✓	BRACKET	NTS
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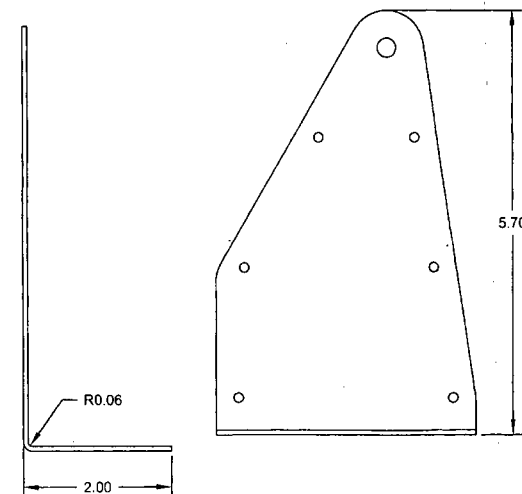
D2195-1F BRACKET FLAT PATTERN



D2195-3 SPACER



D2195-2 BRACKET
MAKE FROM D2195-1F



D2195-1 BRACKET
MAKE FROM D2195-1F

NOTES:

- 1) MATERIAL: -1 & -2: AISI 304/316 S.S. SHEET, 0.064 THICK
PER AMS 5513 OR AMS 5524
REF. DART SPEC M304S
- 3: 5052-H32 ALUMINUM SHEET, 0.500 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
REF. DART SPEC M5052H32S.500
- 2) FINISH: -3 ONLY: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHT

RELEASED
09/01/15

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JS	DRAWING NO.	REV. D
MFG APPR.	JS	D2195	SHEET 3 OF 3
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